

GP 18-08-01	Precommission Cleaning of Steam Generating Equipment and Piping Systems for Rotating Equipment	July 2001
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Precommission Cleaning of Steam Generating Equipment and Piping Systems for Rotating Equipment

GP 18-08-01

Scope

- 1) [I] This Global Practice (GP) covers acceptable techniques for chemical and mechanical precommission cleaning of:
 - a) Fired and unfired steam generators having steam outlet pressures up to and including 1800 psi (12500 kPa)
 - b) Compressor suction and interstage systems
 - c) Steam turbine inlet piping
 - d) Lube and seal oil piping systems
 - e) Positive displacement pump suction piping
- 2) [I] Post cleaning passivation of metal surfaces to prevent pre-startup contamination is also covered by this GP.
- 3) [I] An asterisk (*) indicates that additional information is required. If a job is contracted, this additional information will be furnished by Purchaser.

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1. Documentation

1.1. Proposal Information

- 1) * A specification describing the proposed services, equipment, and procedures shall be furnished to Purchaser for approval by the Owner's Engineer. This specification shall include, but not be limited to, the following:
 - a) [M] Schematic drawings of the circuits to be cleaned and to be used to introduce and circulate chemicals. Drawings shall indicate size and type of all cleaning connections and location of post cleaning inspection points.
 - b) [E], [O] Chemicals to be used and method of introduction and disposal.
 - c) [M] Concentration, temperatures, circulation rates and contact times (minimum, maximum, and working level) of chemical solutions to be used.
 - d) [M] Details of inhibitors to be used, effectiveness of inhibitors against corrosion, and sampling and testing schedule.
- 2) Services proposed by the cleaning Contractor shall not include operating functions on Purchaser's (or Owner's) equipment or facilities.
- 3) * [M] Surface cleanliness standards, pictorial or actual, shall be furnished to Purchaser for approval by the Owner's Engineer. Pictorial standards shall be 5 in. x 7 in. (127 mm x 178 mm) color photos (minimum). Actual standards shall be carbon steel pipe NPS 1½ to 3 (38 mm to 76 mm) by 12 in. (305 mm) long, fully cleaned, and passivated. These standards shall be used for the post cleaning inspections per Section 4.2., Item 2.

1.2. Operating Records

- 1) [M], [R] The cleaning Contractor shall prepare and maintain a continuous log of each cleaning operation, recording all aspects including:
 - a) Chemicals used, including inhibitor
 - b) Temperatures, concentrations, and circulation rate of cleaning solutions
 - c) Test results
- 2) [M], [R] A copy of the log shall be submitted to Purchaser for review with the Owner's Engineer on completion of each cleaning operation.

2. Cleaning Requirements and Methods

[R] The degree of cleaning and surface preparation required, and acceptable methods to accomplish this are specified in Table 1.

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